

Work Order ID 139071 - 2

Tuesday, March 08, 2016 1:02:14 PM

*SPit-1-

139071

Page 1

Item ID: D3278-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Support

Start Date: 3/21/2016 Start Qty: 80.00

80

Cust Item ID:

Required Date: 3/28/2016 Req'd Qty: 80.00

80

Customer:

Reference:

600x
80
80
SPit-2-58x

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3278	Rev C
-------	-------

100

100

SHEAR

0.00

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 2.00" x 1.00" x 2.550" long

80 *e* *mf*
16/03/04

105

105

0.00

Outsource5

Memo

0.00

Outsource process - Machining

ISSUE PO *31709*
MACHINE PER DRWG D3278 REV.C

80 *80* *MAR 15 2016* *DAS*
13 *9-00*

108

108

Receive & Inspect for Damage & Mat'l Certs

0.00

Packaging

Memo

0.00

Packaging

58x *80/6-01-05*



Work Order ID 139071

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Page 2

Item ID: D3278-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Support

Start Date: 3/21/2016 Start Qty: 80.00

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80

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
115	QC5- Inspect part completeness to step on W/O	0.00							16 3-89
115									
QC	Memo	0.00							16/04/06
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.01							
Hand Finishing									
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating									
	START TIME: 10:40. OVEN TEMPERATURE:								
	FINISH TIME: 11:10.								

2-88
30
1987

Work Order ID 139071

Tuesday, March 08, 2016 1:02:14 PM

139071

Page 3

Item ID: D3278-2 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Support
 Start Date: 3/21/2016 Start Qty: 80.00 *80* Cust Item ID:
 Required Date: 3/28/2016 Req'd Qty: 80.00 *80* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00				58			
160									
QC	Memo	0.01					0.00		APR 13 2016
Quality Control									
170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging	Memo	0.01				58	ML5	16-04-13	
Packaging	LOCATION : GA								
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.13							
Quality Control									

ML5 APR 14 2016
 Lm 16/04/13
 16/04-13



Picklist Print

Page 1

Wednesday, March 08, 2016 1:02:13 PM

Work Order ID: 139071

139071

Parent Item: D3278-2

D3278-2

Parent Item Name: Support

Start Date: 3/21/2016

Required Date: 3/28/2016

Start Qty: 80.00

Required Qty: 80.00

Comments:

IPP: A04.04.19New issueKJ/JLM

IPP B 07.09.06 Rev C dwg EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3278-2P		Purchased	No				Each	0.0000		80			
D3278-2P									**				
Support													
M6061T6B1.000X02.00		Purchased	No			100	f	41.4690	0.2337	19.68			
0													
M6061T6B1 000X02 000									**				
6061-T6 Bar 1.00 x 2.00													

Location

Loc Qty

Loc Code

MAT

2.052

M132582

2.052

MAT003

39.417

M133587

12

M133699

12

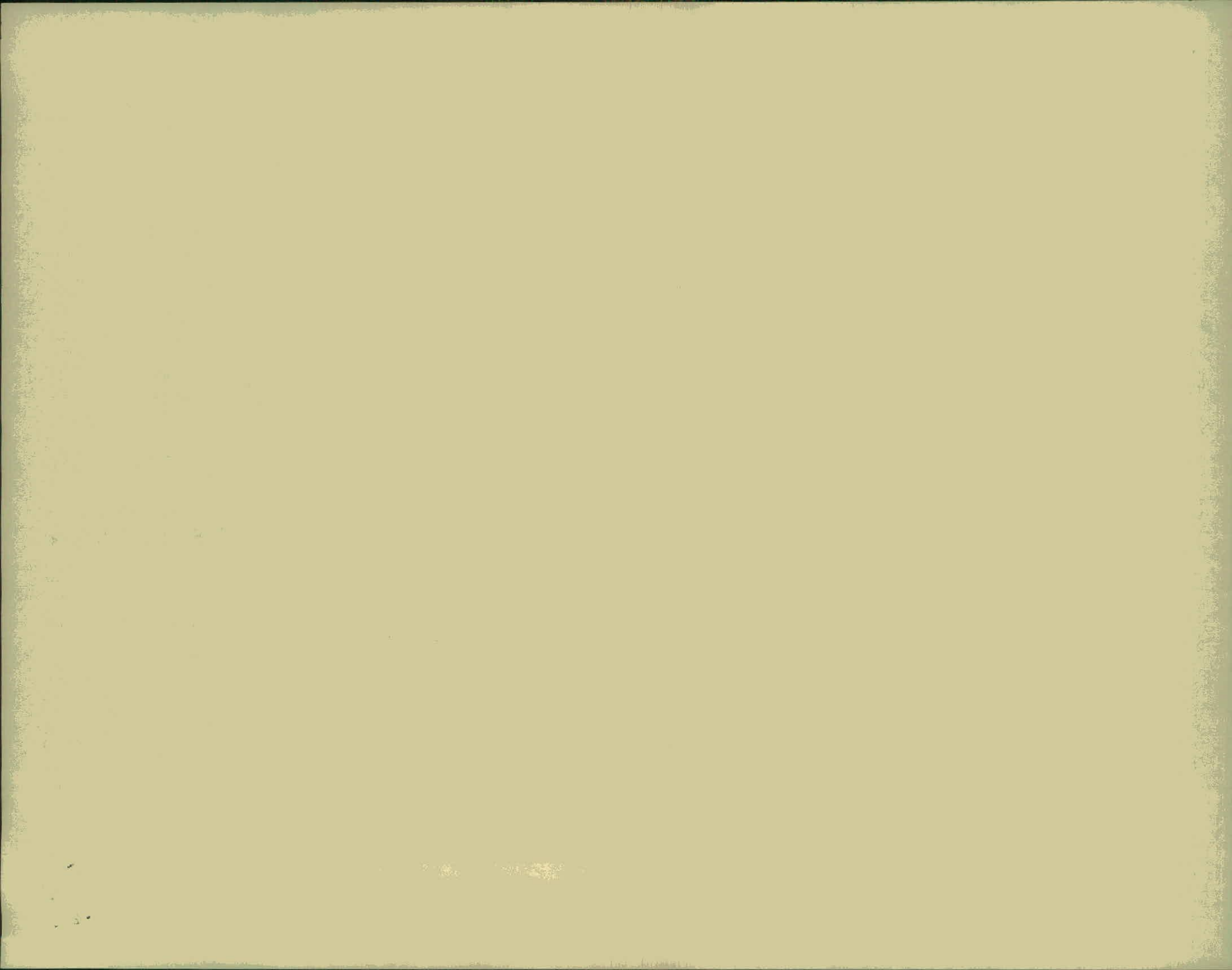
M134067

15.417

12
3.5
2.15

17.65

only
16/03/04



DART AEROSPACE LTD		Work Order: 139071
Description: Support		Part Number: D3278-2
Inspection Dwg: D3278	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

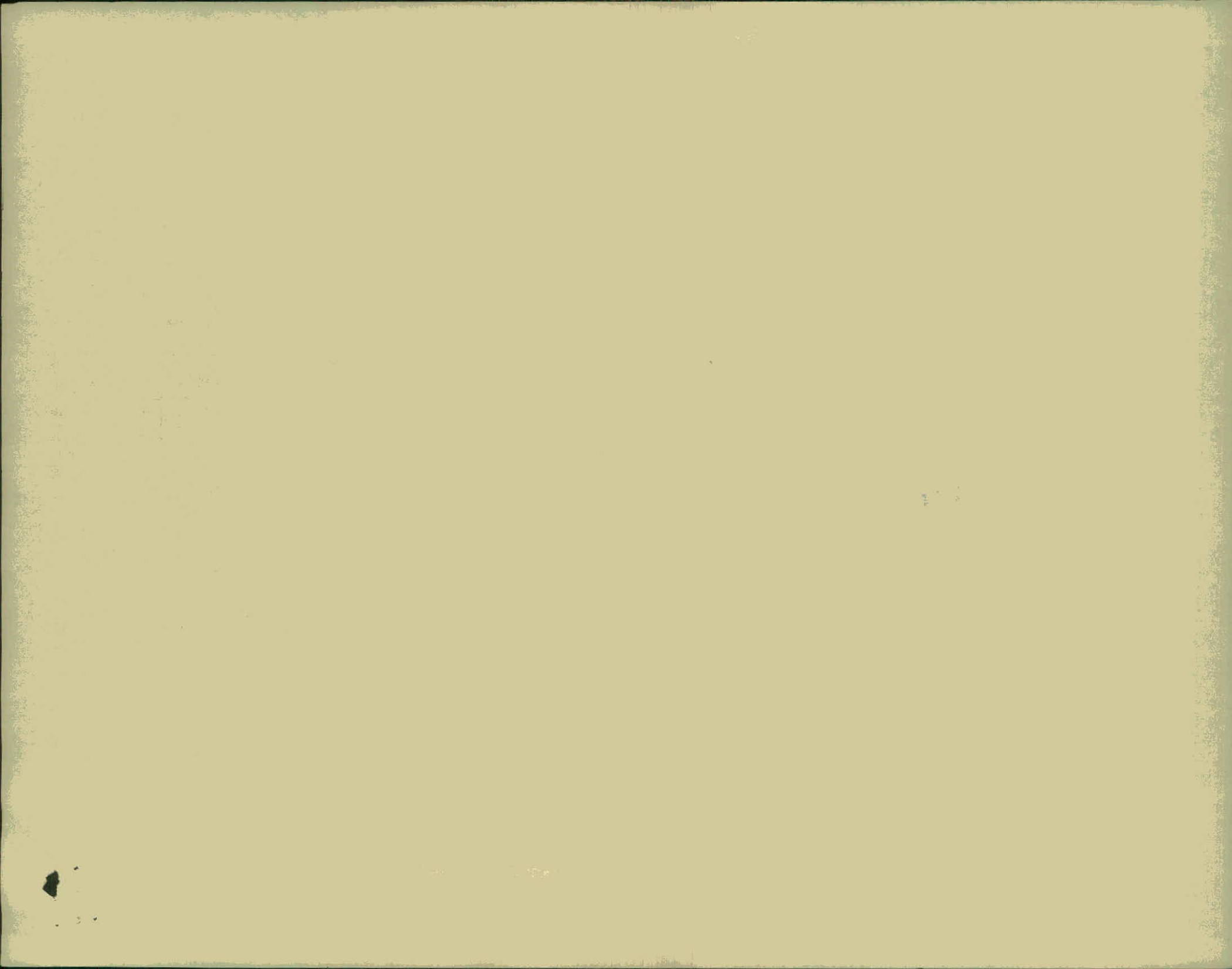
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	0.099	/		ED-6 vern	
0.359	+/-0.005	0.363	/		"	
0.609	+/-0.010	0.610	/		"	
0.250	+/-0.010	0.249	/		"	
1.480	+/-0.005	1.481	/		"	
R0.125	+/-0.010	0.125	/		R-6	
0.119	+0.005/-0.004	0.121	/		ED-6 vern	
2.439	+/-0.010	2.434	/		"	
1.980	+/-0.010				ED-6 vern	
R0.13	+/-0.030	0.125	/		R-6	
Ø0.257	+0.005/-0.000	0.258	/		ED-6 vern	
R0.375	+/-0.010	0.375	/		R-6	
0.875	+/-0.010	0.876	/		ED-6 vern	
0.500	+/-0.010	0.503	/		ED-6 vern	
R0.400	+/-0.010	0.4	/		R-6	
R1.00	+/-0.030	1.0	/		R-6	
1.720	+/-0.010	1.719	/		ED-6 vern	
R0.125	+/-0.010	0.125	/		R-6	
0.125	+/-0.010	0.119	/		ED-6 vern	

Measured by:	Audited by: DAS 16	Prototype Approval:	N/A
Date:	Date: 289 16/04/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	

1314

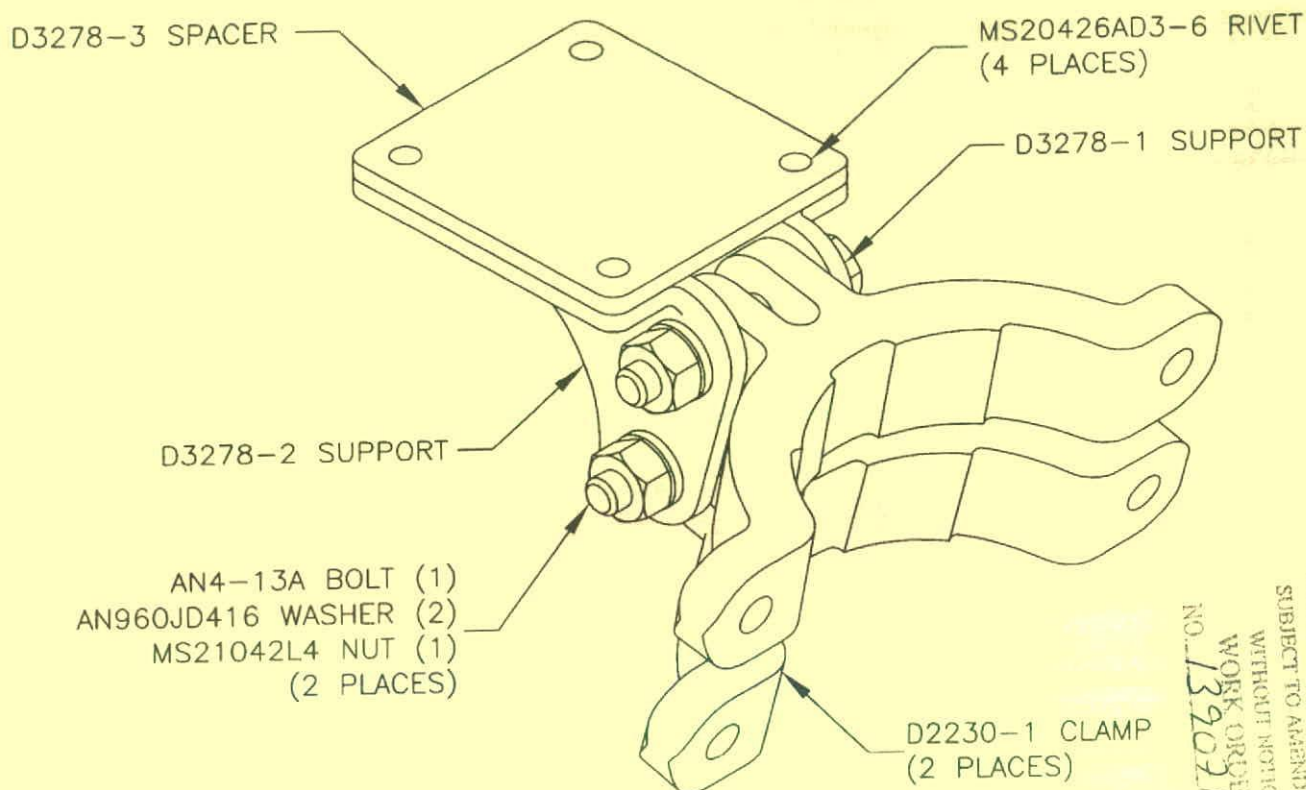




DESIGN 97	DRAWN BY SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07 08-08

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 139021
MCS
16-03-08

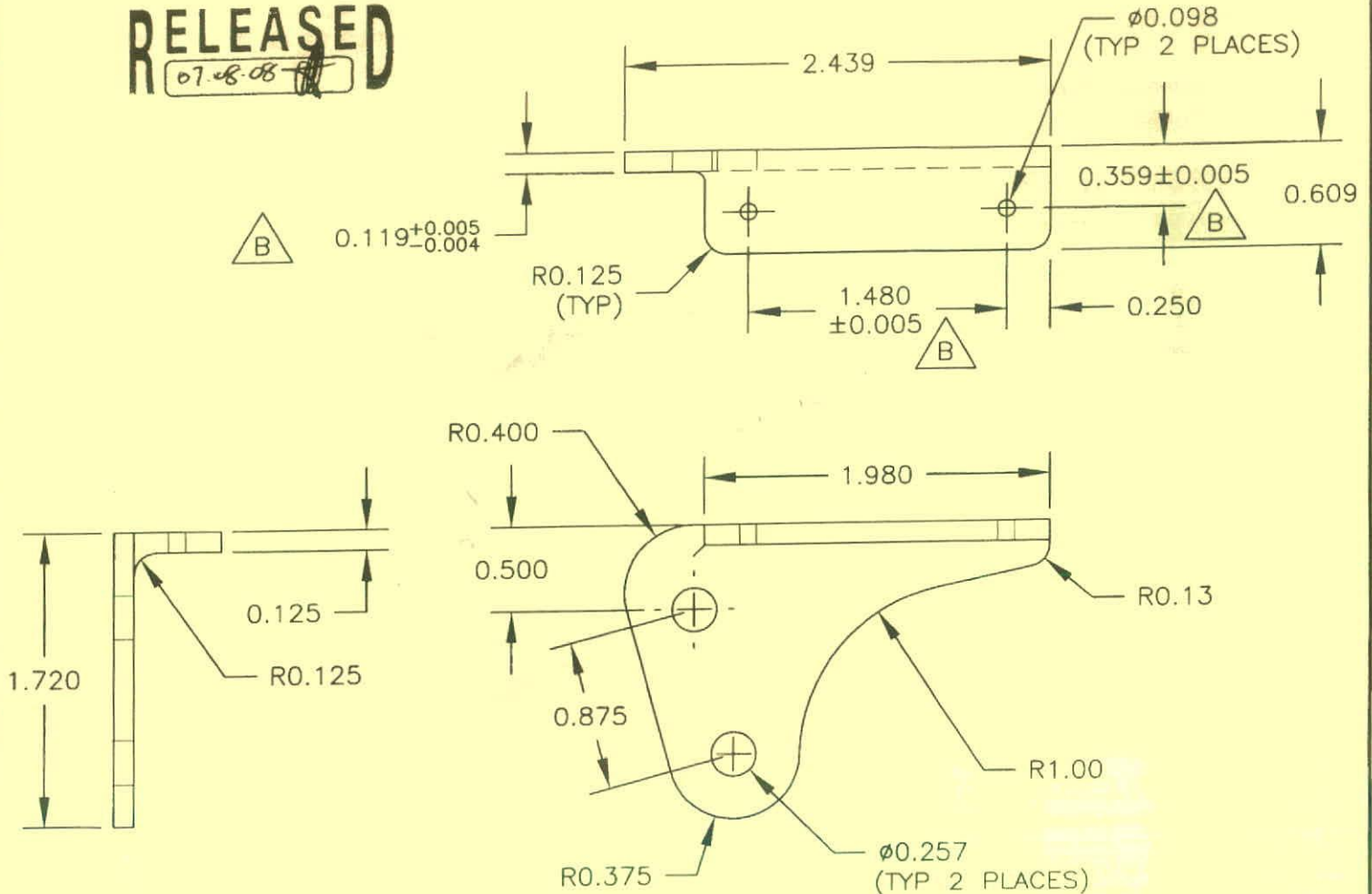
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DART

DESIGN <i>qp</i>	DRAWN BY <i>dc</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

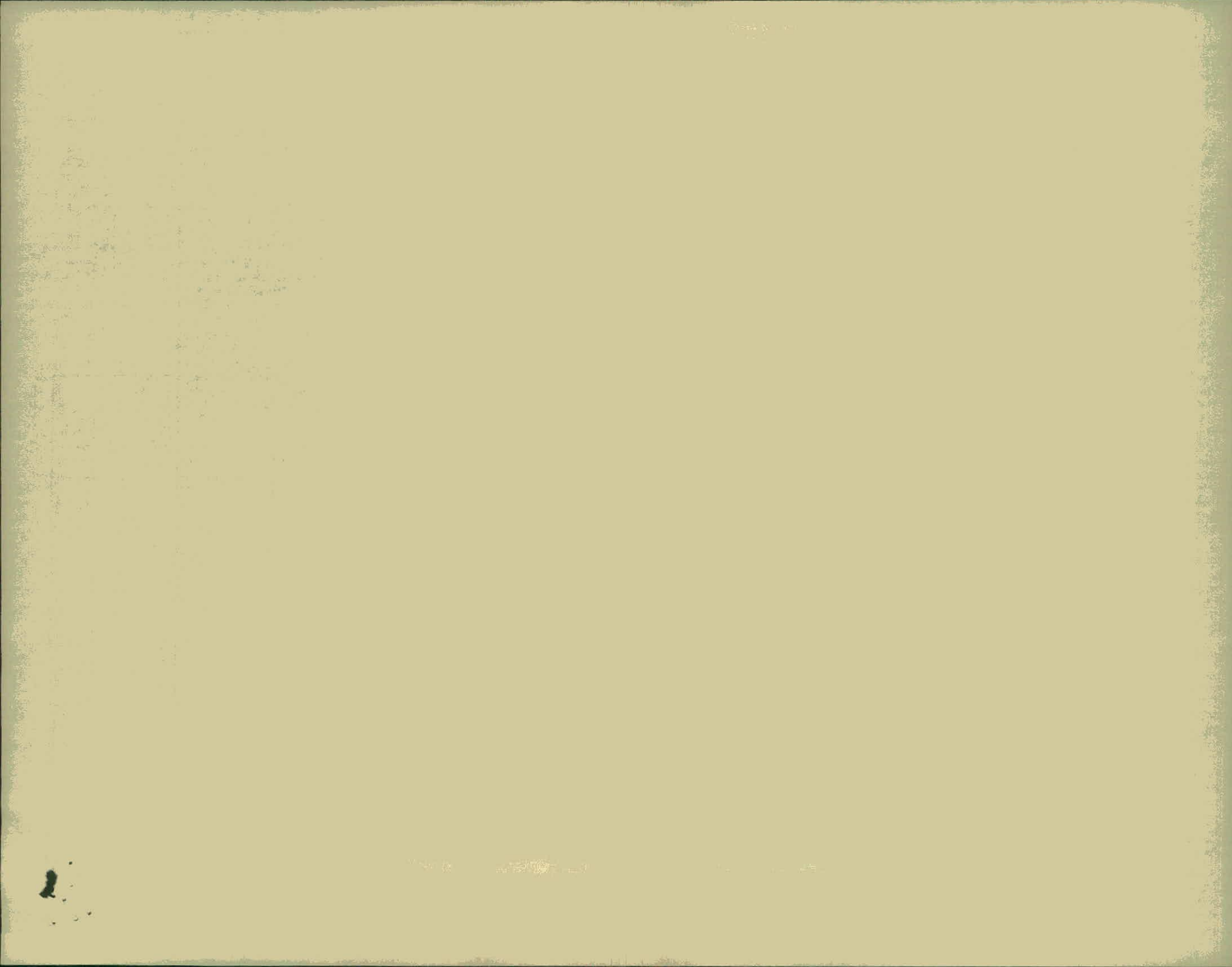
RELEASED
07-08-08

D3278-1 SUPPORT (SHOWN)
D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

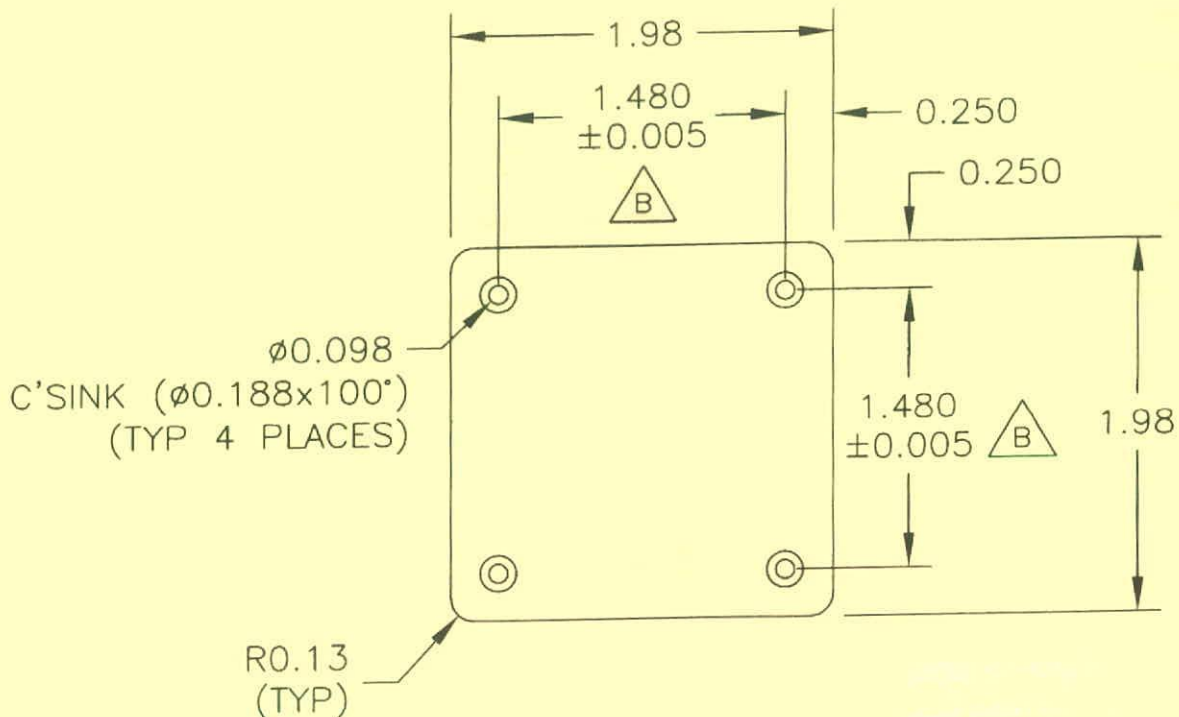
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DART

DESIGN <i>gp</i>	DRAWN BY <i>SC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO31709

Purchase Order Date 3/15/2016

PO Print Date 3/15/2016

Page Number 1 of 3

Order From :

VC-MET003

Ship To : DART AEROSPACE LTD

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

MAR 15 2016

Contact Name

Vendor Phone 613 678 3957

Ship To Contact

Ship To Phone

Ship Via: Dart Truck

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 10

CAD

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3278-1P ASAP AS PER DWG D3278 REV. C B141498	Support	4/5/2016 Yes 4/5/2016		80.00 Each	\$23.20	\$1,856.00
Line Total:							\$1,856.00
2	D3278-2P AS PER DWG D3278 REV. C B139071	Support	4/5/2016 Yes 4/5/2016		80.00 Each	\$23.20	\$1,856.00
Line Total:							\$1,856.00

Note:

3/15/2016



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.:

21181

Date:

Mar 31, 2016

Page:

1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 31709	Sold By: VanDenYssel, David
Shipped By: your truck	Ship Date: Mar 31, 2016

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3278-1 Support, as per drawing D3278 Rev.C	Each	80	80 59	
D3278-2 Support, as per drawing D3278-2 Rev.C	Each	80	60	
D3404-1 GHW LUGS, as per drawing D3404-1 Rev.C Part D3404-1 requires Chamfer on all edges 45° .060°	Each	67	67	
D3886-1 Lug, as per drawing D3886 Rev.B	Each	57	57	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by <u>Spillio - 4-4</u>		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
60	D3278-1	Lug Material Batch# 141498	31709
60	D3278-2	Lug Material Batch# 139071	31709
67	D3404-1	Lug Material Batch# 142472	31709
57	D3886-1	Lug Material Batch# 142654	31709

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, March 31, 2016

